

Work Order ID 143594

143594

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Item ID: D412-704-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Ass'Y
 Start Date: 4/1/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: SU **20160316** Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D412-704-041	Rev B								
100		Small Fab	0.00						
100									
Small Fab		Memo	0.02						
Small Fab		Assemble pedal as per Dwg D412-704-041							
		Tighten & Torque Bolts as per Dwg D412-704-041							
110		QC5- Inspect part completeness to step on W/O	0.00						
110									
QC		Memo	0.00						
Quality Control									
120		Pick Kit	0.00						
120									
Packaging		Memo	0.00						
Packaging									

DAS
36
9-89

3x 16/04/25

(3)

DAS
38
9-89

APR 25 2016

3

APR 26 2016

DAS
6
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____			

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Item ID: D412-704-041 Accept ***N900040100*** Setup Start ***NS1***
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 Start Date: 4/1/2016 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 4/15/2016 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00				3	DAS 28 9-89	APR 2 6 2016	
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>St 2290</u> Memo	0.00 0.00				3		APR 2 6 2016	DAS 6 9-89
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.01				MCS		APR 2 6 2016	

MCS APR 2 6 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : ☐					
Misidentified ☐	Past Due ☐						

Picklist Print

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Work Order ID: 143594

143594

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:B05.01.28Removed hardware on Step 2; Added Figures 1-3KJ/RF
 IPP Rev:C06.03.08 Re-format EC
 IPP Rev:D 07-03-20 Added Dwg D412-704-041 07-03-20 JLM
 IPP Rev:E 07.05.02 Reformat EC
 IPP Rev:F 08-10-08 as per revB DD veriifed by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4610-5 *D4610-5* Shim		Manufactured	No				Each	27.0000		3		16/04/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST112				27					
				117120				3					
				142240				24					
AN3-10A *AN3-10A* Bolt		Purchased	No			100	Each	194.0000	1	3		16/04/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				1					
				m132763				1					
				over003				100					
				m134249				100					
				ST349				93					
				m133992				93					
AN315-4R *AN315-4R* Nut		Purchased	No			100	Each	118.0000	1	3		16/04/15	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST331				118					
				M128978				118					

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

DAS

AN4-10A

Purchased

No

100

Each

87.0000

1

3

36

9-89

AN4-10A

Bolt

16/04/15

Location

Loc Qty

Loc Code

CA

13

M129682

13

ST345

74

131677

5

M133234 ~

69

3

AN4-12A

Purchased

No

100

Each

141.0000

2

6

DAS

36

9-89

AN4-12A

Bolt

16/04/15

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

131

m133990

31

m134180 ~

100

6

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

AN4-13A	Purchased	No	100	Each	803.0000	1	3	DAS
AN4-13A								36
Bolt								9-89

**

16/04/15

Location	Loc Qty	Loc Code
FG	20	
122808	20	
GA	120	
m134167	120	
O003	300	
m134497	300	
over003	300	
m134260	300	
ST344	63	
m133998	13	
m134039	50	

D3204-041	Manufactured	No	100	Each	1.0000	1	3	DAS
D3204-041								36
Release Pedal Assembly								9-89

**

16/04/15

Location	Loc Qty	Loc Code
GA	1	
135587	1	

D3205-1	Manufactured	No	100	Each	0.0000	1	3	DAS
D3205-1								36
Pedal Bracket								9-89

**

16/04/15

D3205-3	Manufactured	No	100	Each	9.0000	1	3	DAS
D3205-3								36
Back Plate								9-89

**

16/04/15

Location	Loc Qty	Loc Code
GA	9	
135626	9	

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Work Order ID: 143594

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

D3206-1 Manufactured No

100 Each 5.0000 1 3

D3206-1

Pedal Arm

DAS
36
9-89

16/04/15

Location

Loc Qty

Loc Code

GA 5

137608 5

3

D3209-041 Manufactured No

100 Each 1.0000 1 3

D3209-041

Bracket Assembly

DAS
36
9-89

16/04/15

Location

Loc Qty

Loc Code

GA 1

135476 1

B142253 (3)

MS21042L3 Purchased No

100 Each 2,670.000 1 3

MS21042L3

Nut

DAS
36
9-89

16/04/15

Location

Loc Qty

Loc Code

FP001 100

m133790 100

GA 861

m133790 61

m134360 800

3

OVER007 1200

m134360 1200

ST304 509

m134039 509

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Work Order ID: 143594

143594

Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

MS21042L4

Purchased

No

100

Each

3,093.000

5

15

DAS
36
9-89

MS21042L 4

Locknut

**

16/04/15

Location

Loc Qty

Loc Code

FP001

37

m133363

37

GA

447

m133769

447

15

OVER007

1500

m134502

1500

ST303

1012

m134055

1012

ST305

97

m130922

97

MS24694-S102

Purchased

No

100

Each

92.0000

1

3

DAS
36
9-89

MS24694-S102

Screw

**

16/04/15

Location

Loc Qty

Loc Code

ST283

92

124814

52

m128976

40

3

MS9519-10

Purchased

No

100

Each

11.0000

1

3

DAS
36
9-89

MS9519-10

Bolt

**

16/04/15

Location

Loc Qty

Loc Code

GA

9

m133790

9

ST273

2

m129198

2

M134573 (32)

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Work Order ID: 143594

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0363J

Purchased

No

100

Each

1,852.000

5

15

NAS1149D0363.I

Washer

**

16/04/15 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

40

m130799

40

ST263

1812

m134055

812

m134370

1000

NAS1149D0416J

Purchased

No

100

Each

4,302.000

3

9

NAS1149D0416.I

WASHER

**

16/04/15 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

256

m131511

256

ST260a

1986

m131511

1986

ST264

2060

m131511

2060

NAS1149D0463J

Purchased

No

100

Each

3,488.000

11

33

NAS1149D0463.I

WASHER

**

16/04/15 DAS
36
9-89

Location

Loc Qty

Loc Code

GA

237

M129390

41

M132035

196

ST263

2263

M134039

2263

ST269

988

M132317

100

M132677

888

M134508
33x

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Work Order ID: 143594

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

AN3-6A

Purchased

No

120

Each

273.0000

2

6

AN3-6A

Bolt

APR 20 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

over003

175

M134055

175

ST349

98

M133932

98

MS21042L3

Purchased

No

120

Each

2,670.000

2

6

MS21042L3

Nut

DAS
6
APR 20 2016

DAS
28
9-89

Location

Loc Qty

Loc Code

FP001

100

m133790

100

GA

861

m133790

61

m134360

800

OVER007

1200

m134360

1200

ST304

509

m134039

509

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Parent Item: D412-704-041

D412-704-041

Parent Item Name: Pedal Ass'Y

Start Date: 4/1/2016

Required Date: 4/15/2016

Start Qty: 3.00

Required Qty: 3.00

NAS1149D0332J

Purchased

No

120

Each

1,877.000

4

12

NAS1149D0332.J

Washer

Handwritten signature

**DAS
28
9-88**

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

8

m133498

8

GA

118

m132677

118

ST260a

600

m133988

600

ST264

1000

m134502

1000

ST266

137

m133498

137

12

